

Date: Monday, 23/07/2007 2:24:37 PM  
 User: Linda Lacelle

## Process Sheet













Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHIM  
 Job Number : 33281  
 Estimate Number : 10916  
 P.O. Number : *N/A* Part Number : D34423  
 This Issue : 23/07/2007 S.O. No. : *N/A* Drawing Number : D3442 REV A  
 Prsht Rev. : *NC* Project Number : N/A  
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 33281 Material : *N/A*  
 Written By : *[Signature]* Due Date : 30/07/2007 Qty: 20 Um: Each  
 Checked & Approved By : *[Signature]*  
 Comment : Est. A 05.09.02 New issue KJ/JLM  
 est B 07.07.23 waterjet EC verified by: JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet
		
	Comment: Qty.: 0.0263 sf(s)/Unit Total : 0.5250 sf(s) 304/316 SS 0.032" Sheet batch: <i>M105061 m102159</i> <i>SAN 07/08/07</i>	
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg D3442 Dwg Rev: <i>A</i> Prog Rev: <i>A</i> 2-Deburr if necessary <i>SAN 07/08/08 20</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAN 07/08/08 (20)</i>	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK <i>En 07/08/09 (20) center</i>	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>5793</i> <i>6 7/8/9 (20)</i>	

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 33281

Part Number: D34423

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 20, 07/08/10

Job Completion



Handwritten: 07/08/10

Date: Wednesday, 7/4/2007 10:17:27 AM  
 User: Kim Johnston

# **Process Sheet**

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SHIM
<b>Job Number</b> :	33281		
<b>Estimate Number</b> :	10916		
<b>P.O. Number</b> :		<b>Part Number</b> :	D34423
<b>This Issue</b> :	7/4/2007	<b>Drawing Number</b> :	D3442 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	1/1	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	26740	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	7/20/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	20
<b>Comment</b> :	Est. 4 05/09/02 New issue KJ/JLM	<b>Um:</b>	Each

## **Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operations:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_  
 Email or Ship DXF file to vendor  
 Laser Cut flat pattern per Dwg D3442  
 Possible Supplier: Industrial Laser  
 Material release note is required

2.0	D34423F	Shim
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**Comment:** Qty.: 1.0000 U(s)/Unit Total : 20.0000 U(s)  
 Shim

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Recieve & Inspect for Transit Damage  
 Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 1/4/2007 10:17:27 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 33281

Part Number: D34423

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

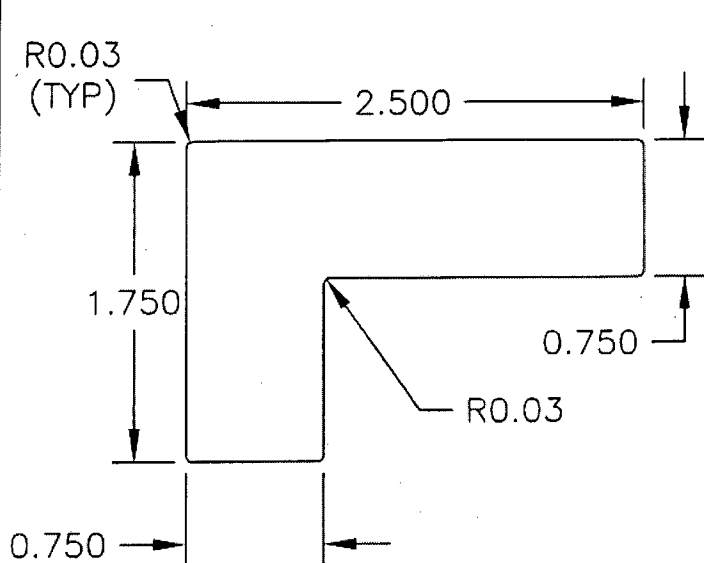
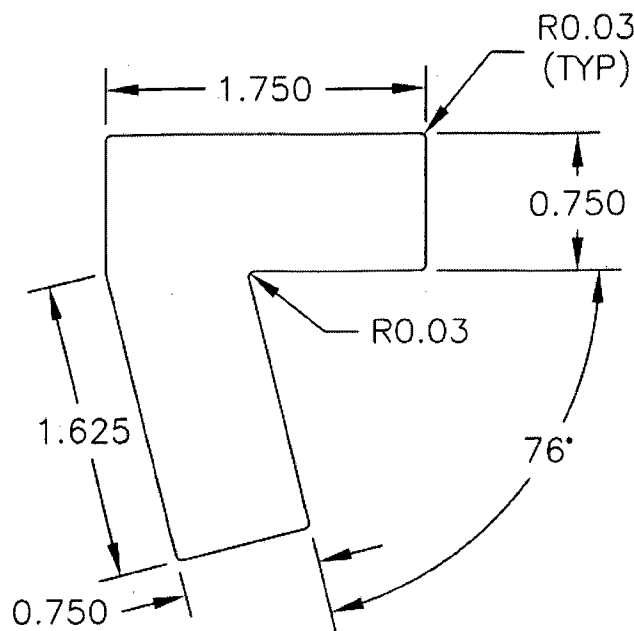
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

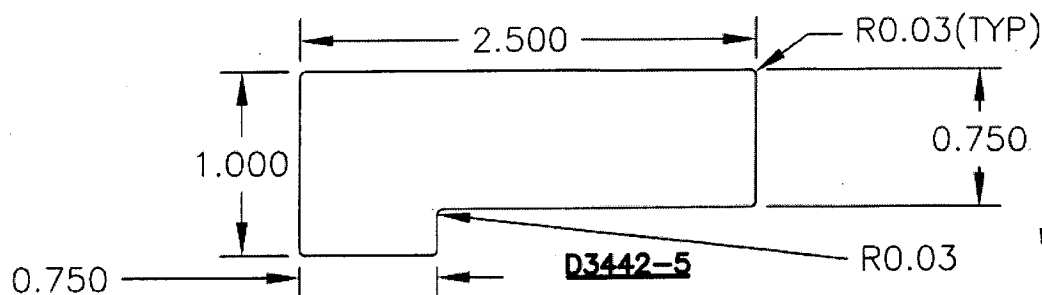
NOTE: Date & initial all entries

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03		TITLE SHIM	SCALE 1:1
A	05.06.03	NEW ISSUE	

**D3442-1****D3442-3****D3442-1/-3 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)  
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3442-5****D3442-5 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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